

Work Order ID 91671

91671

Page 1

October-12-12 2:56:05 PM

Item ID: D4121-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hose Assembly
 Start Date: 10/12/12 Start Qty: 9.00 ***9*** Cust Item ID:
 Required Date: 10/12/12 Req'd Qty: 9.00 ***9*** Customer:
 Reference: scrap - old rev

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4121	D								

130 Small Fab 0.00

130

Small Fab

Small Fab

Small Fab

Memo

PULL FROM STOCK

2 X D4121-3 B71290 ✓✓

4 X D4121-3 B72245 ✓✓✓

3 X D4121-3 B72466 ✓✓✓✓

SCRAP/DESTROY- OLD REV.

0.00

(10) SAD 12-11-16

160 QC21- Final Inspection - Work Order Release 0.00

160

QC

Quality Control

Memo

0.00

12/11/19 JG

W 12.11.16

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

List Lots

October-12-12 2:52:52 PM

Page 1 of 1

Criteria : Item ID: d4121-3 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D4121-3 Hose Assembly	Main Warehouse ST	63024	11/02/10	0.0000		QC21		
	Main Warehouse ST192	71290	5/04/12	2.0000		QC21		
	Main Warehouse ST192	72245	5/04/12	4.0000		QC21		
	Main Warehouse ST192	72466	10/11/12	3.0000		QC21		
Total:				9.0000				

91671 h

NCR: Yes / No

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Linda Lacelle

From: David Shepherd <dshepherd@dartaero.com>
Sent: October-11-12 11:37 PM
To: 'Linda Lacelle'
Cc: 'Eric Downing'
Subject: RE: PHI - Keevin

Linda,

Looking at dwg D4121, would it be possible to convert each of these into 2 x D4121-1 hoses?
If not, I think we should just scrap these parts.
And yes ... I remember this fiasco far too well ☹

David

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: October-11-12 6:52 AM
To: 'David Shepherd'
Cc: 'Eric Downing'
Subject: RE: PHI - Keevin
Importance: High

David,

Do you remember this mess? I sure do...I have 10 x D4121-3's in stock that say to ship to ERA only, can we still use these??

LL

From: David Shepherd [<mailto:dshepherd@dartaero.com>]
Sent: November-14-11 1:04 PM
To: 'Linda Lacelle'
Cc: 'Marc Bellavance'; 'Sian Willems'
Subject: RE: PHI - Keevin

An NCR should be created ... Root cause: David Shepherd is an idiot ☺

Like Linda says, Mike Burkes at Era told me that it would be better to have the hoses that went into the manifold have straight ends rather than 90 degree ends, so we accommodated this request only to find out that straight ends don't make much sense. Also, PHI needs an extra couple of inches on the D4121-3 hose to get it installed, even though Era didn't have a problem.

It is difficult to design kits for an aircraft that is 3000 miles away and Era has provided some erroneous feedback along the way.

David

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: November-14-11 10:31 AM
To: 'Sian Willems'

NCR: Yes / No

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Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved														
FAULT CATEGORY														
Landing Gear			General											
<input type="checkbox"/>	Bending		<input type="checkbox"/>	Bend		<input type="checkbox"/>	Grain		<input type="checkbox"/>	Ovalized		<input type="checkbox"/>	Pressure/Forced	
<input type="checkbox"/>	Centre Not Concentric to O/S		<input type="checkbox"/>	BOM/Route		<input type="checkbox"/>	Hardware		<input type="checkbox"/>	Over/Under tolerance		<input type="checkbox"/>	Temperature/Cure	
<input type="checkbox"/>	Cracks		<input type="checkbox"/>	Broken/Damaged		<input type="checkbox"/>	Inspection Incomplete		<input type="checkbox"/>	Part Incorrect		<input type="checkbox"/>	Weld	
<input type="checkbox"/>	Crushed/Crimped		<input type="checkbox"/>	Burr		<input type="checkbox"/>	Instructions Incomplete/Unclear		<input type="checkbox"/>	Part Lost/Missing		<input type="checkbox"/>	Wrong Stock Pulled	
<input type="checkbox"/>	Cuffs		<input type="checkbox"/>	Contamination		<input type="checkbox"/>	Maintenance		<input type="checkbox"/>	Part Moved		<input type="checkbox"/>	Other	
<input type="checkbox"/>	Heat Treat		<input type="checkbox"/>	Countersink		<input type="checkbox"/>	Mislabeled		<input type="checkbox"/>	Positioned Wrong				
<input type="checkbox"/>	Inspection Strip in Tube		<input type="checkbox"/>	Cut Too Short		<input type="checkbox"/>	Misread		<input type="checkbox"/>	Power Loss/Surge				
<input type="checkbox"/>	Ripples in Bend		<input type="checkbox"/>	Drill Holes		<input type="checkbox"/>	Offset							
<input type="checkbox"/>	Torque Waves in Extrusion		<input type="checkbox"/>	Drawing		<input type="checkbox"/>	Out of Calibration							
<input type="checkbox"/>	Turning Sequence		<input type="checkbox"/>	Finish		<input type="checkbox"/>	Out of Sequence							
<input type="checkbox"/>	Wave/Twist in Tube		<input type="checkbox"/>	Folio		<input type="checkbox"/>	Outside Dimensions							

Cc: dshepherd@dartaero.com; Marc Bellavance
Subject: RE: PHI - Keevin

The hoses are all wrong, we had to order up some new ones...it was feedback from the customer that wasn't communicated correctly...David, do you have anything to add?

LL

From: Sian Willems [<mailto:swillems@dartaero.com>]
Sent: November-14-11 12:29 PM
To: 'Linda Lacelle'
Subject: RE: PHI - Keevin

What's the issue? Is there an ncr or other quality document I can reference?

Thanks,

Sian Willems

Customer Support
T: 1-613-632-5200 ext 239
F: 1-613-632-5246
C: 1-613-676-0577
swillems@dartaero.com



Product Documentation: Verify Revision Status/Download [HERE](#)

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: November 14, 2011 11:53 AM
To: Marc Bellavance; Willems, Sian
Cc: dshepherd@dartaero.com
Subject: PHI - Keevin
Importance: High

Please issue a N/C to ship today, 4 x D4121-3 **rev.**, **D** hoses & 3 x D4121-5 **rev. D** hoses.....to Keevin @ PHI...the -3's must ship today, the -5's will ship tomorrow or wed, depending when we get these in...

Thx
Linda

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd
Hawkesbury, ON
Phone: 613 632 9577
Fax: 613 632 1053
Cell: 613 676 1655

NCR: Yes / No

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other